

Date: Thursday, 02/10/2008 10:34:34 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW
Job Number	: 42413		
Estimate Number	: 11176		
P.O. Number	:	Part Number	: D32903
This Issue	: 02/10/2008 S.O. No. :	Drawing Number	: D3290 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : THERMOFORMING	Drawing Revision	: C
Previous Run	: 42120	Material	:
Written By	:	Due Date	: 12/10/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.10.02</u>		
Comment	: Est. A 04.08.18 New issue KJ/RF		
	: Est. B 06.05.09 Ecn 798 EC		
	: Est. C 07.05.29 Thermoform in-house DL		
	: Est. D 07.09.28 rev C dwg EC verified by: DD		
	: Est. E 07.11.28 Add -Hand finish deburring DL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 3.1500 sf(s)/Unit Total: 31.5000 sf(s)
 Polycast II or plexiglass G .125"

109570X9 HB 8-10-20
 109187Y4 HB 8-10-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3290 HB 8-10-20
 Dwg Rev: C HB 8-10-3
 Prog Rev: C

(B)

2-Deburr if necessary SAN 08-14-15

(3)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-10-20
 HB 8-10-3



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/10/21 HB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/10/2008 10:34:34 AM
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Job Number:



Seq. #: Machine Or Operation: Description :

5.0 HAND FINISH TH HAND FINISHING THERMOFORMING



X13

Comment: HAND FINISHING THERMOFORMING

Without removing protective skin
remove sharp edge by degurring.

DL 08/11/25

6.0 THERMOFORMING THERMOFORMING MACHINE



X13

Comment: 1-THERMOFORM as per Drawing D3290 and Folio FTA001

Dwg. Rev. C

Folio Rev. A

2-Engrave part# & batch#,
(D3290-3)

DL 08/11/25

7.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



X13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances

DL 08/11/25

8.0 QC8 SECOND CHECK



Comment: SECOND CHECK

EBD 08/11/26 X13

9.0 HAND FINISH TH HAND FINISHING THERMOFORMING



X13

Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches if required

DL 08/11/26

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 08/11/26 X13

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA assembly

DL 08/11/27 X13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/27 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

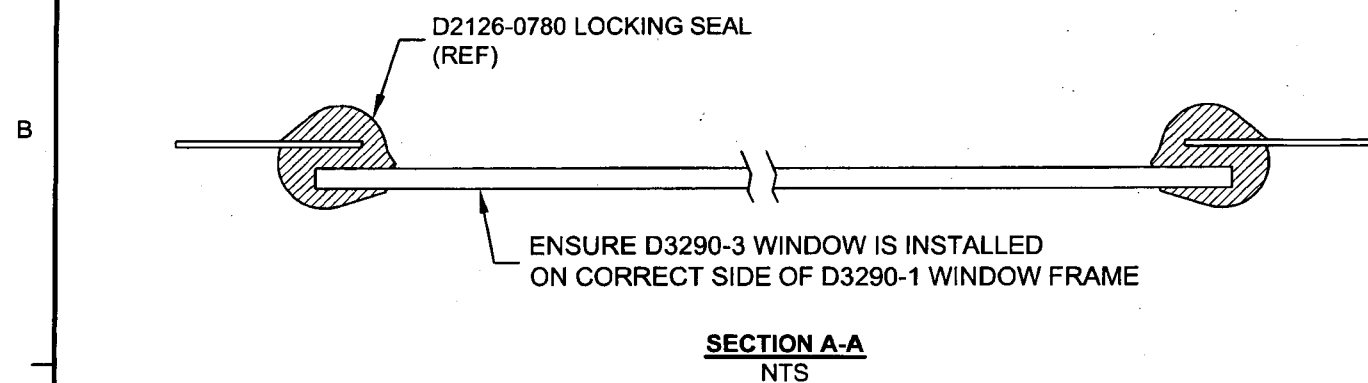
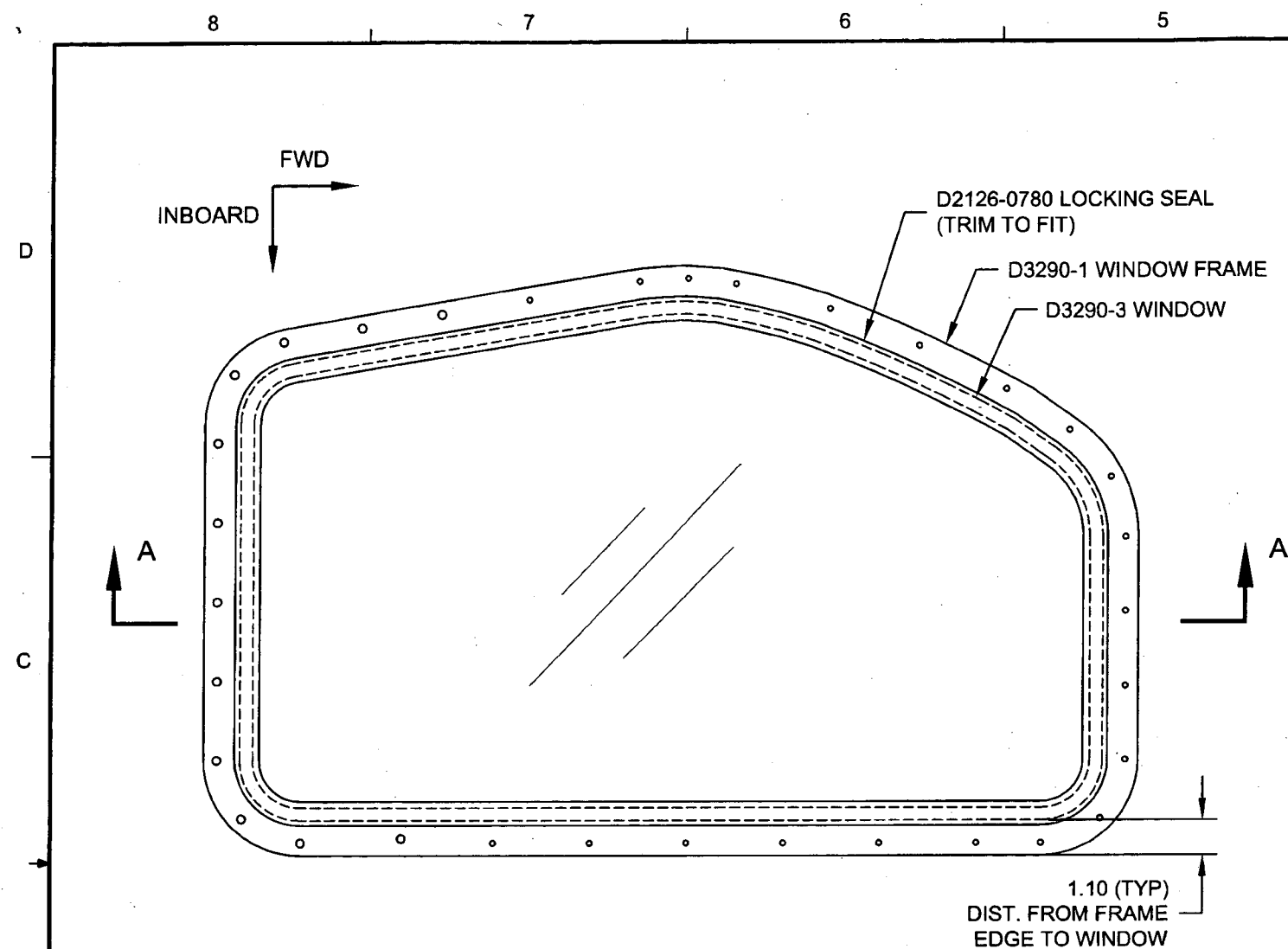
DART AEROSPACE LTD		Work Order: 42413
Description: Window		Part Number: D3290-3
Inspection Dwg: D3290	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.58	+/-0.030	26.58	X			
16.08	+/-0.030	16.08	X			
13.79	+/-0.030	13.79	X			
12.40	+/-0.030	12.40	X			
8.81	+/-0.030	8.81	X			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 8-10-3 8-10-20	Date: 08/10/21	Date:	N/A
Rev	Date	Change	Revised by KJ/EC/DD
A	08.01.16	New Issue	Approved

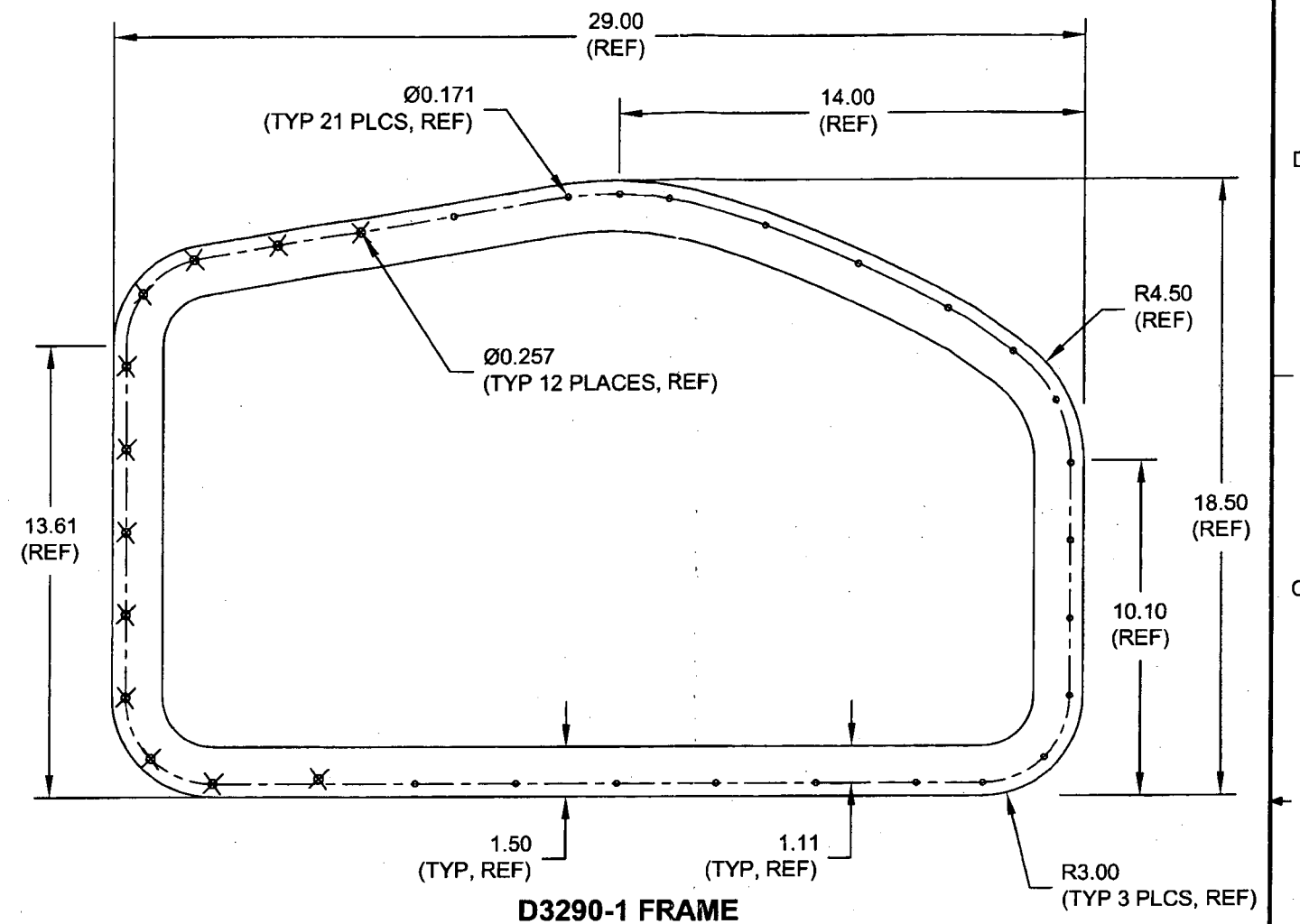


D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED



D3290-1 NOTES:

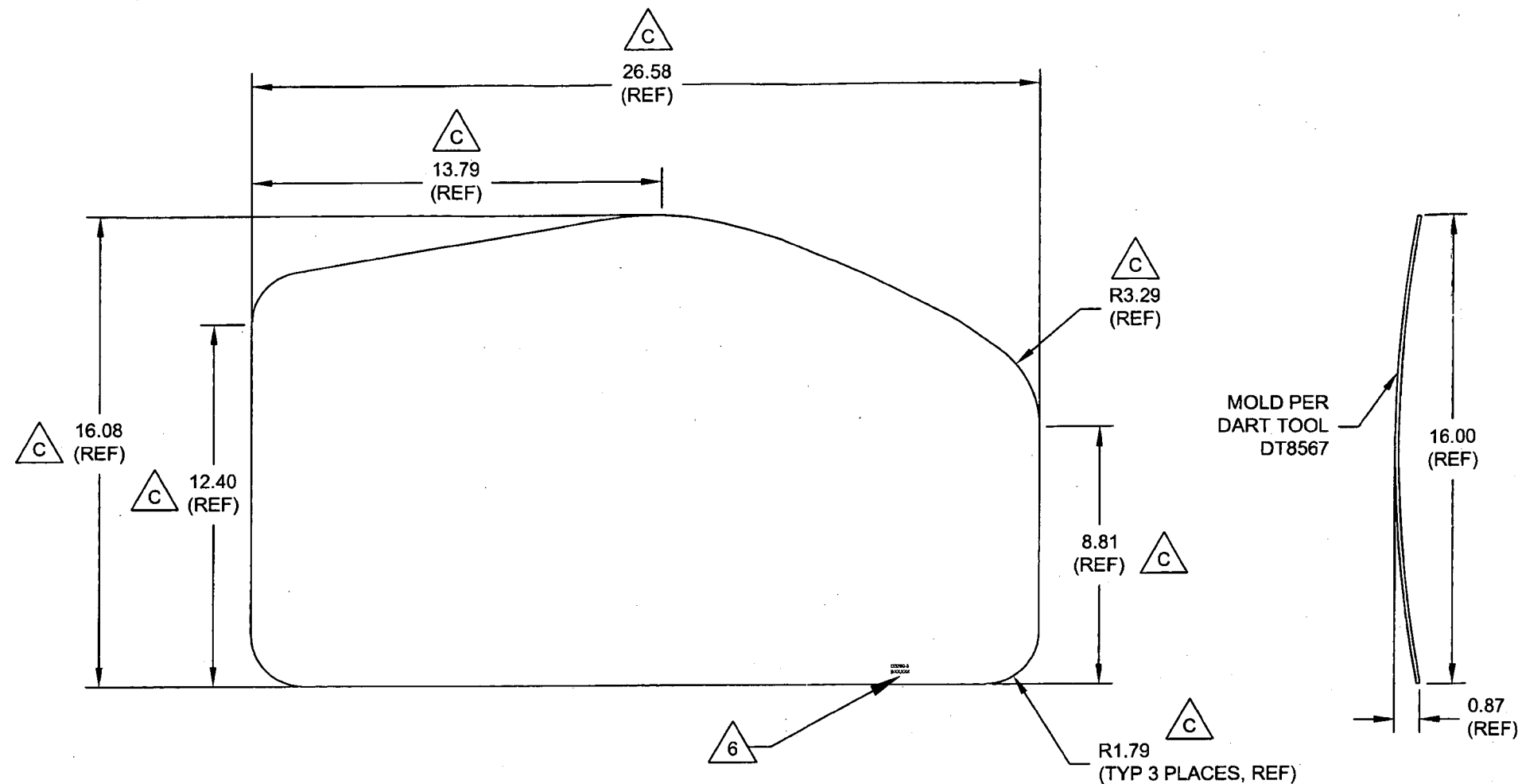
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.09.22

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WORK ORDER
NO. 212413

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3290	REV. C SHEET 1 OF 2
TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
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D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

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WORK ORDER
NO. 42413

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C
MFG. APPR.	<i>[Signature]</i>	D3290 SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	REPLACEMENT WINDOW ASSEMBLY 1:5
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